

# Work Order ID 115593

\*115593\*

Page 1

April-04-14 10:14:10 AM

Item ID: D3284-011 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bearing  
 Start Date: 4/04/14 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 4/04/14 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 14-04-04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3284	Rev B								

100 0.00  
 \*100\* PURCHASING  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 23802 to Eagle Copters Order P/N: 205-060-101-001 Certificate of Conformity is required  
CY 14/04/14 (4)

110 0.00  
 \*110\* Receive & Inspect for Damage & Mat'l Certs  
 Packaging Memo 0.00  
 Packaging Ensure certificate of conformity is attached  
44/4/14 (4)

120 0.00  
 \*120\* QC5- Inspect part completeness to step on W/O  
 QC Memo 0.00  
 Quality Control  
4/4/21  
4

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 115593

\*115593\*

Page 2

April-04-14 10:14:10 AM

Item ID: D3284-011 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearing  
 Start Date: 4/04/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 4/04/14 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location <u>9T036</u>	0.00				<u>4x</u>		<u>14-4-21</u>	DAS 26 9-89
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

ML3 14-04-21

APR 04-21

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
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Supplier									
Training									
Transport									
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# Picklist Print

Page 1

April-04-14 10:14:09 AM

Work Order ID: 115593

**\*115593\***

Parent Item: D3284-011

**\*D3284-011\***

Parent Item Name: Bearing

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A04.05.13New IssueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
205-060-101-001		Purchased	No			100	Each	0.0000	1	4			
<b>*205-060-101-001*</b>									<b>**</b>				
Rod Bearing End													

*Rec'd 4/08/14*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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### FAULT CATEGORY

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## SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



**NOTE:**

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH  
 MIN F<sub>tu</sub> = 90 Ksi  
 MIN F<sub>ty</sub> = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

115593 MLS  
1404-04

RELEASED

2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. REV. B D3284 SHEET 1 OF 1	
MFG. APPR.			
APPROVED		TITLE SCALE ADJUSTABLE ENGINE MOUNT NTS	
DE APPR.			
DATE	09.07.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO23802

Purchase Order Date 4/14/2014

PO Print Date 4/14/2014

Page Number 1 of 2

Order From : VU-EAG002

EAGLE COPTERS MAINTENANCE LTD.  
823 MCTAVISH ROAD N E  
CALGARY, AB T2E 7G9  
CA

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FOUR  
6/4/2014

Contact Name  
Vendor Phone 403-250-7370  
  
Ship To Contact  
Ship To Phone  
Ship Via: FedEx PI collect  
Ship Acct:

Buyer Chantal Lavoie  
Customer POID  
Customer Tax # 10127-2607  
Terms Net 30  
Currency USD  
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	205-060-101-001  AS PER DWG D3284 REV. B B115593	Rod Bearing End	4/17/2014 Yes 4/17/2014	4.00 Each	\$304.52	\$1,218.08
Line Total:						\$1,218.08
2	71401-45  Procurement Quality Clauses A005 right of entry A016 personnel qualification A026 certification of material conformance A040 notification of quality escape A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	4/17/2014 No 4/17/2014	1.00	\$0.00	\$0.00

Note:

4/14/2014



# Eagle Copters Maintenance Ltd

823 McTavish Rd, NE  
Calgary, Alberta T2E 7G9  
Canada

## Packing Slip

April 16, 2014

Telephone: (403) 250-7370

Fax: (403) 250-7110

Shipment number: SH#14-001150

Customer PO number: PO23802

Ship To: Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada

Phone: (613)632-5200

Ship Via: FED EX

Carrier Terms:

Waybill: 798564600606

Customer PO number: PO23802

Item	Part Number	Part Description	Current Location	Qty UOM	Serial Number	Lot Number
1	205-060-101-001	ROD END	Shipping Area	4 Each		LT-14-00587
Type of sale: Outright						

Sales Order Number: SO14-00565.001

Eagle PO Number: PO-14-002248.1

Fedex PI  
email Chantal Tracking #  
clavoie@dartaero.com

All Parts being sent on this packing slip have the original certification on file at Eagle Copters Ltd.

\* End of Report \*

**Eagle Copters Maintenance Ltd**

823 McTavish Road, NE Calgary, Alberta T2E 7G9

**TCCAAMO Approval No. 6-81**

**LOT #: LT-14-005875**



Sold To: SO14-00565.001

Sold Date: 4/16/2014 2:18:39PM

**PART #: 205-060-101-001**

Description: ROD END

Serial No:

Condition: New

Qty Sold: 4.00

Cure Date:

Manufacturer Bell Helicopter (Manufacturer)

Cycles

Hours

Total Time:

TSO:

Time Remaining:

Details of work performed/reason for removal

**Receiving Inspection**

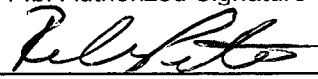
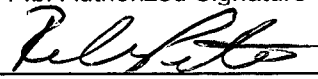

Additional work to be performed upon installation

April 16, 2014

Inspector

Lic. Tech. Stamp



1. Approving National Authority/Country <b>Transport Canada</b>		Authorized Release Certificate <b>FORM ONE</b>			3. Form Tracking Number <b>SO14-00565.001</b>
4. Approved Organization Name and Address <b>Eagle Copters Maintenance Ltd</b> <b>823 McTavish Road NE,</b> <b>Calgary, Alberta, Canada, T2E 7G9</b>					5. Work Order/Contract/Invoice <b>INV-14-001458.1</b>
6. Item <b>1</b>	7. Description <b>ROD END</b>	8. Part Number <b>205-060-101-001</b>	9. Quantity <b>4</b> <b>Each</b>	10. Serial Number/ Lot Number <b>LT-14-005875</b>	11. Status/Work <b>Inspected</b>
12. Remarks <b>Above product was purchased new from Eagle approved vendors. This product has been passed through receiving inspection in accordance with the TCCA approved Eagle Maintenance policy manual and all certification kept on file at Eagle Copters.</b> Time Since New: <u>00</u> Time Since Overhaul: <u>NA</u> Other: <u>NA</u>					
<del>13a. Certifies that the items identified above were manufactured in conformity to:</del> <input type="checkbox"/> Approved design data and are in condition for safe operation <input type="checkbox"/> Non-approved design data specified in block 13			14a. <input checked="" type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in block 12 Certifies that, unless otherwise specified in block 12, the work identified in block 11 and described in block 12 has been performed in compliance with the Canadian Aviation Regulations		
<del>13b. Authorized Signature</del> 		<del>13c. Certificate/Approval No.</del>		14b. Authorized Signature  	
<del>13d. Name</del>		<del>13e. Date</del>		14c. Certificate/Approval No. <b>TC AMO Approval No. 6-81</b>	
<del>13d. Name</del>		<del>13e. Date</del>		14d. Name <b>ROB PETERS</b>	
<del>13d. Name</del>		<del>13e. Date</del>		14e. Date (mm/dd/yyyy) <b>04/16/2014</b>	

#### Installer Responsibilities

This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a and 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.